

Work Order ID 65045

Wednesday, January 05, 2011 3:17:34 PM



Page 1

Item ID: D3121-21

Accept



Setup Start



Revision ID:

Item Name: Bolt

Stop



Start Date: 1/6/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan: *CMF*

Date: *11-01-05* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3121

Rev E

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn D3121-21 ☐ 2-Identify as D3121-21 ☐ 3-Deburr break all sharp edges
0.005" to 0.010"

SA 11/1/06

24 *0*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 11/1/06

24 *0*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SA 11/10/06

24 *0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3121-21

Accept

Revision ID:

Item Name: Bolt

Start Date: 1/6/2011 Start Qty: 24.00

Required Date: 1/14/2011 Req'd Qty: 24.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 235 0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/01/06 (24)11/01/06 MF

11-01-06

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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, January 05, 2011 3:17:34 PM

Work Order ID: 65045

Parent Item: D3121-21

Parent Item Name: Bolt



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP A 04.02.09 New issue KJ/DS
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500 		Purchased	No			110	f	104.7480	0.0417	1.0008			
303 HEX BAR .500												SA 11/01/06	

Location

Loc Qty

Loc Code

MAT037

104.748

109778

99.548

109846

5.2

1 foot

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

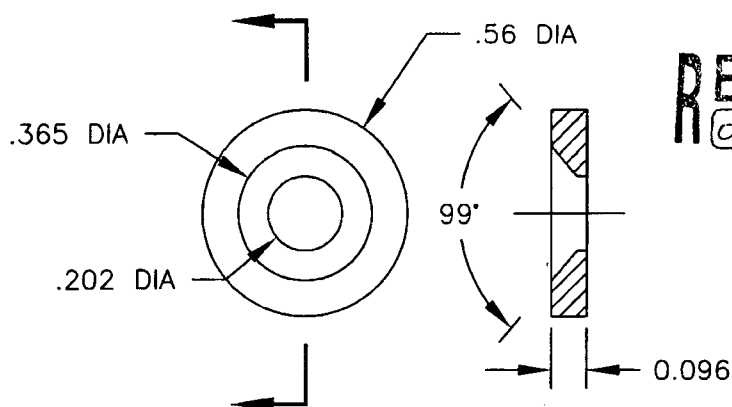
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

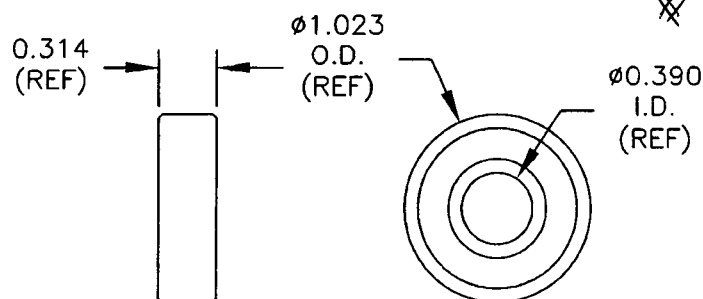
NOTE: Date & initial all entries

DART

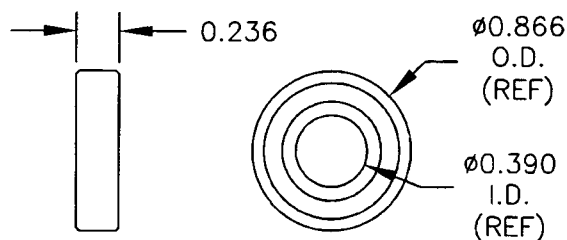
DESIGN <i>[Signature]</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

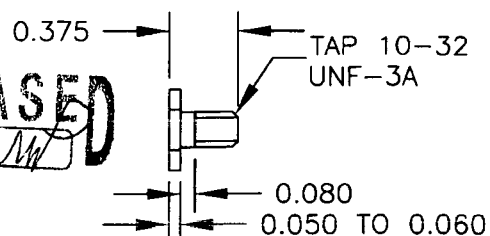
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

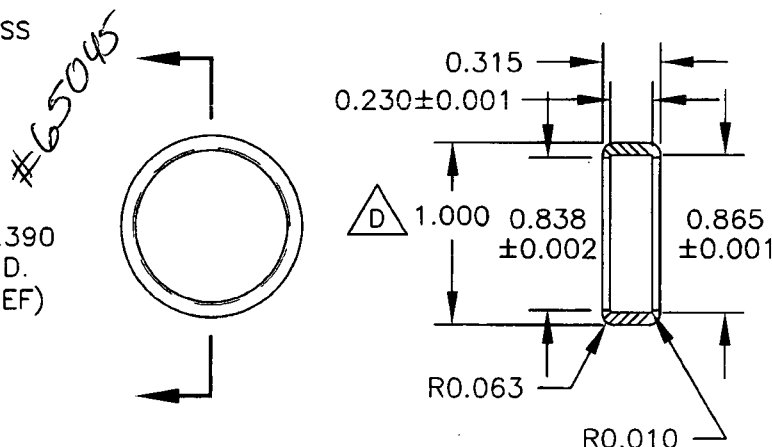
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

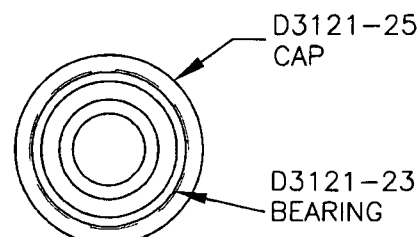
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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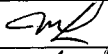
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

DART AEROSPACE LTD		Work Order: 65 045
Description: Bolt		Part Number: D3121-21
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	+/-0.010	.378	/		Visual	OK - 9
0.050 - 0.060	N/A	.055	/		7	7
0.080	+/-0.010	.080	/			
10-32UNF3A	N/A	10-32 UNF3A	/			
Major Diameter	Max: 0.190 Min: 0.184	.187	/			
Over wire	Max: 0.2146 Min: 0.2123	.214	/			

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 11/11/06	Date: 11/10/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.27	New Issue	KJ/RF	
B	06.03.09	Dwg Rev. updated	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dwg Rev. updated	KJ/EC/DD	
E	08.07.23	Dimensions updated	KJ/DD 	

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